





Date: Friday, 9/21/2007 12:58:21 PM
User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---|---|------------------|---|-----------------|
| Customer | : | CU-DAR001 Dart Helicopters Services | Drawing Name | : | 206L BASKET LID |
| Job Number | : | 34770B | | | |
| Estimate Number | : | 11274 | | | |
| P.O. Number | : | | Part Number | : | D2252043 |
| This Issue | : | 9/21/2007 S.O. No. | Drawing Number | : | D2252 REV E |
| Prsht Rev. | : | NC | Project Number | : | N/A |
| First Issue | : | // Type : LARGE FAB ASSY | Drawing Revision | : | E |
| Previous Run | : | 34479B | Material | : | |
| Written By | : |  | Due Date | : | 10/20/2007 Qty: |
| Checked & Approved By | : |  09.24 | | | 1 Um: Each |
| Comment | : | Est Rev: REVISD AS PER REV E 05-12-06 JLM | | | |

Additional Product

Job Number: 

| Seq. #: | Machine Or Operation: | Description : |
|---------|---|---|
| 1.0 | M304TS0750W065  | 304 SQ Tube.75x.75x.065W  |

Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Ba

Batch: M105604

PD 07-10-10

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|

Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

PD 07-10-10

| | | |
|-----|-------|-------------|
| 3.0 | D2329 | Label Plate |
|-----|-------|-------------|

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D2329 | Label Plate | B299 |

PD 07-10-10

| | | | |
|-----|--------|----------------|--|
| 4.0 | D23271 | Spacer Bushing | |
|-----|--------|----------------|--|

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2327-1 | Bushing | B31693 |

PD 07-10-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:58:21 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 34770B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

~~B21603~~ B31603

PD 07-10-10

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chanel

B34445

PD 07-10-10

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M105913

PD 07-10-16

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: M105524

PD 07-10-16

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/10/25

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/25

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068

M-6 07/10/26

(1X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:58:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 34770B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/10/29

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/10/29

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U 07.11.07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



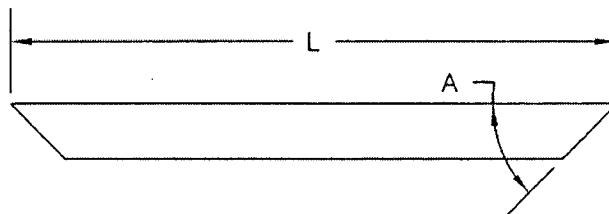
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| | | | |
|------------------|----------------|--|------------------------|
| DESIGN KE | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2252 | REV. E SHEET 1 OF 5 |
| DATE 05.11.10 | | TITLE BASKET ASSEMBLY (206L) | SCALE NTS |
| C | 95.12.11 | RE-DRAWN | |
| D | 99.09.14 | MODIFIED LATCH, D2581 WAS D2255-3 | |
| E | 05.11.10 | D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19 | |

| Qty -041 | Qty -043 | Part Number | Description | L | A |
|-------------|-------------|-------------|------------------------|-------|----|
| X | | D2252-041 | BASKET ASSEMBLY | | |
| | X | D2252-043 | LID ASSEMBLY | | |
| | 2 | D2232-1 | HINGE | | |
| 2 | | D2232-3 | HINGE | | |
| 5 | | D2235-1 | RIB | | |
| 2 | 2 | D2252-1 | FRAME | 25.50 | 45 |
| 2 | | D2252-3 | FRAME | 96.00 | 45 |
| | 2 | D2252-7 | FRAME | 24.00 | 90 |
| 1 | | D2252-9 | FRAME | 10.25 | 90 |
| 1 | | D2252-11 | FRAME | 25.00 | 90 |
| 1 | | D2252-13 | FRAME | 42.00 | 90 |
| 1 | | D2252-15 | FRAME | 15.00 | 90 |
| 4 | | D2252-17 | FRAME | 19.78 | 53 |
| | 2 | D2252-19 | FRAME | 95.27 | 45 |
| | 2 | D2252-21 | FRAME | 30.82 | 90 |
| | 1 | D2252-23 | FRAME | 30.62 | 90 |
| 2 | | D2253-1 | LUG | | |
| 2 | | D2254 | GUSSET | | |
| | 1 | D2327-1 | BUSHING | | |
| 1 | | D2327-3 | BUSHING | | |
| | 1 | D2329 | LABEL PLATE | | |
| 4 | 2 | D2581 | MOUNTING CHANNEL | | |
| A/R | A/R | | 3/4-16F EXPANDED METAL | | |

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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Technical drawing showing a cross-section of a structural member. The drawing includes the following details:

- Top View:** Shows a longitudinal section with dimensions 29.64, 34.50, and 29.64 (REF). It includes callouts for D2232-1 (TYP BOTH ENDS) and D2581.
- Side View:** Shows a cross-section with a total width of 95.27^{+0.00}_{-0.01} and a total height of 25.50 (REF). The section is divided into three vertical panels with widths of 30.82, 34.50, and 30.82.
- Material Callouts:**
 - D2232-1 (TYP BOTH ENDS) - Reinforcement bars at the ends.
 - D2581 - Reinforcement bars in the longitudinal section.
 - D2252-19 (E) - Reinforcement bar in the bottom left panel.
 - D2252-21 - Reinforcement bar in the top middle panel.
 - D2252-23 (E) - Reinforcement bar in the middle middle panel.
 - D2252-7 - Reinforcement bar in the bottom middle panel.
 - D2252-1 - Reinforcement bar in the bottom right panel.
- Other Callouts:**
 - D2327-1 (REF) SEE DETAIL F - Points to the top left corner.
 - D2252-1 - Points to the top left corner of the cross-section.

WELD ALL JOINTS
AS SHOWN

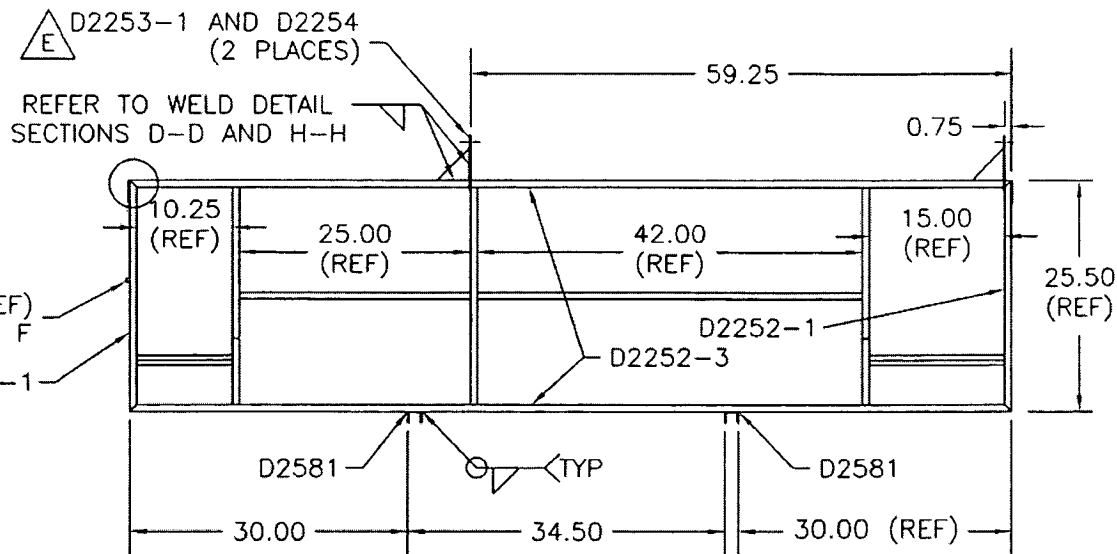
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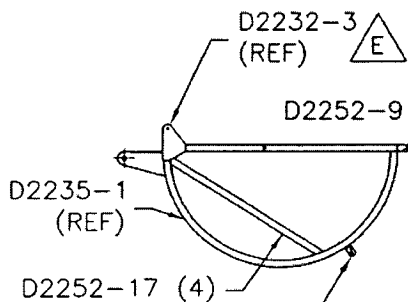
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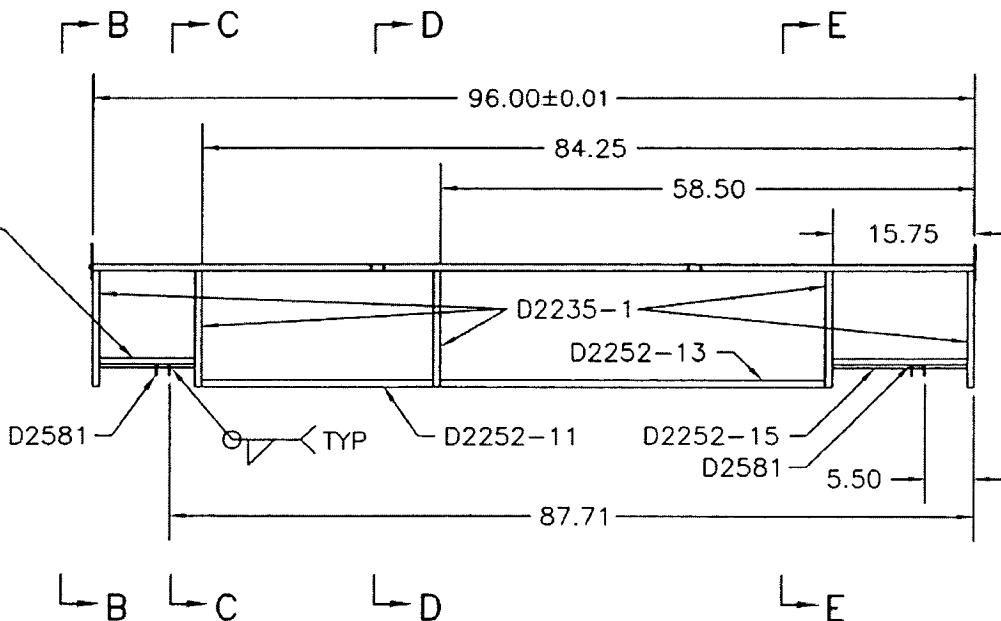
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| DATE | 05.11.10 | TITLE | D2252 | REV. E |
| | | | | SHEET 3 OF 5 |
| | | | | SCALE |
| | | | | NIS |



WELD ALL JOINTS
AS SHOWN



WELD D2581
WITH LARGE HOLE
ON THIS SIDE



D2252-041 BASKET FRAME

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05.11.26

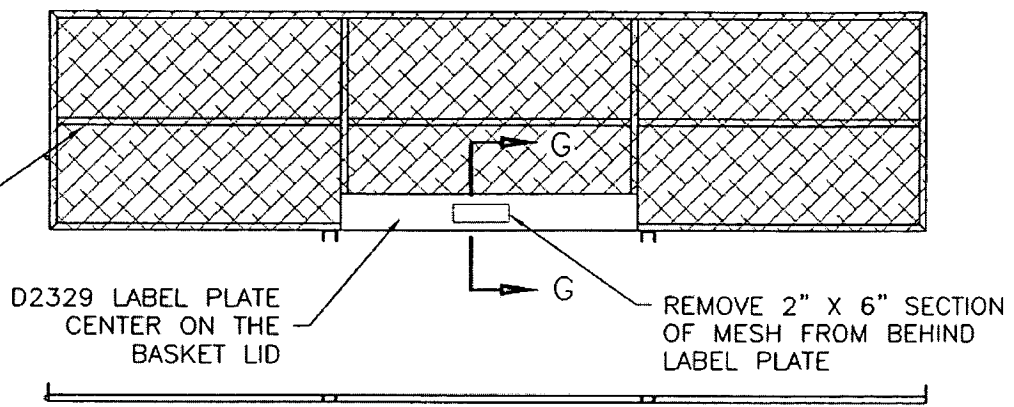
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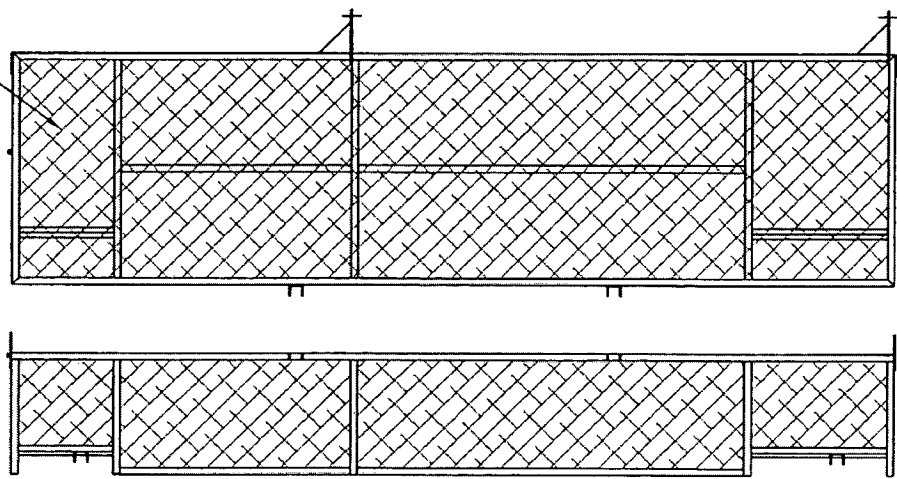
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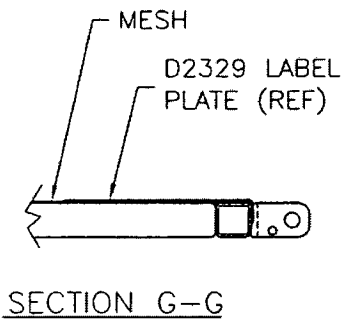
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| DATE | 05.11.10 | TITLE | BASKET ASSEMBLY (206L) | REV. E SHEET 4 OF 5 |
| | | SCALE | NIS | |



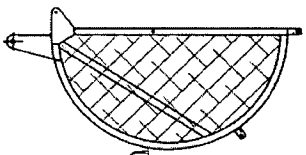
D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME

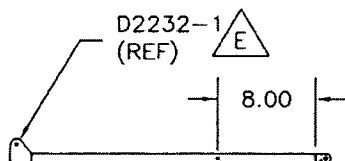
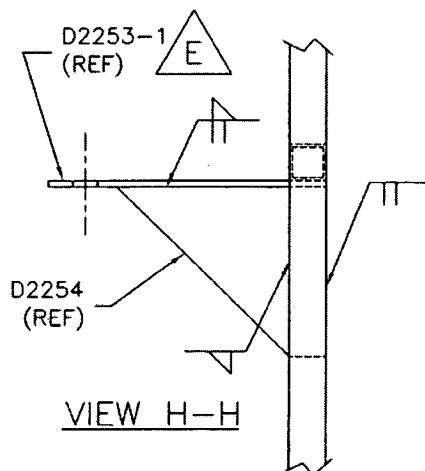
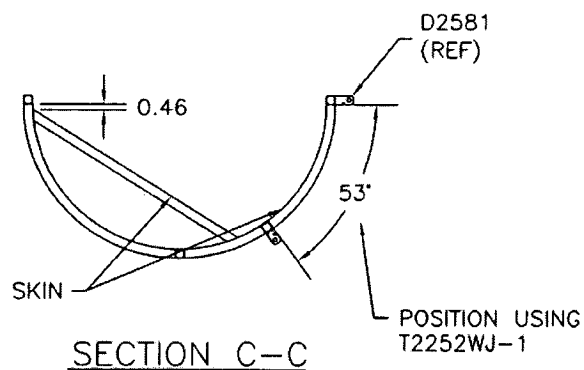
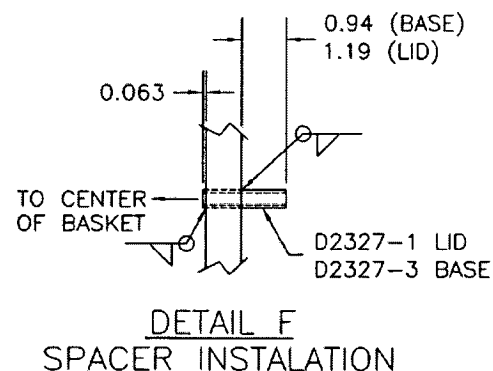
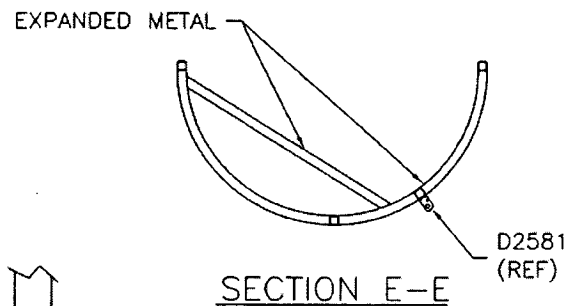


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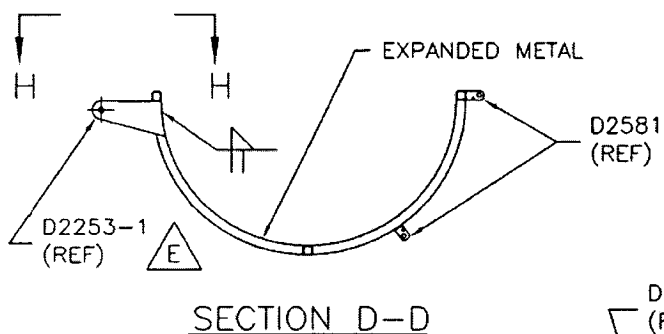
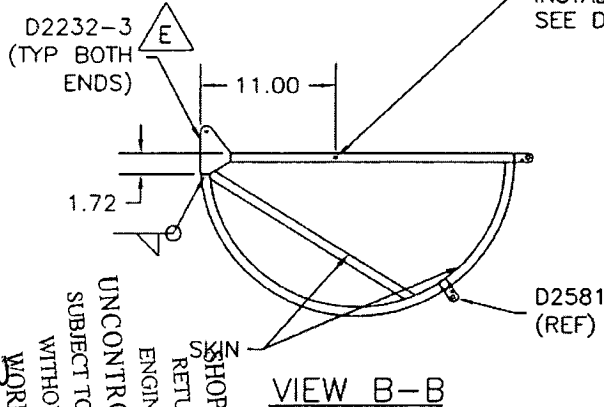
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| DATE | 05.11.10 | TITLE | BASKET ASSEMBLY (206L) | REV. E |
| | | DRAWING NO. | D2252 | SHEET 5 OF 5 |
| | | SCALE | NTS | |



DRILL 3/8 HOLE AND
INSTALL D2327-1/-3
SEE DETAIL F



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